

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023342**Date Inspected:** 19-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu Yoo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

4AW to 4BW

This Quality Assurance (QA) Inspector along with Mr. Mani (Ct QA) and Mr. Levi (ABF) verified the Longitudinal Stiffener Sweep recorded as 7mm. Recorded the offset reading at locations 1,2,3,4 and 5.

3AW to 3BW

This Quality Assurance (QA) Inspector along with Mr. Mani (Ct QA) and Mr. Levi (ABF) verified the Longitudinal Stiffener sweep and recorded the offset reading at locations 1,2,3,4 and 5. Reading recorded was out of tolerance as per DCP.

ZPMC QC offered re-inspection after heat straightening and noticed the reading are within tolerance.

5BE

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This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) at cross beam to FL3 stiffener. The weld joint no. Seg 024-PP33 168 and 169 is in progress. The welder is identified as 067964. Welder was welding in 4F position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2114-FCM-1.

5BE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) at cross beam to FL3 stiffener. The weld joint no. Seg 024-PP33 16 and 17 is in progress. The welder is identified as 037840. Welder was welding in 4F position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2114-FCM-1.

5BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) at cross beam to FL3 stiffener. The weld joint no. Seg 024-PP33 68 and 69 is in progress. The welder is identified as 066261. Welder was welding in 4F position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2114-FCM-1.

5BE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) at cross beam to FL3 stiffener. The weld joint no. Seg 024-PP33 086 and 087 is in progress. The welder is identified as 067572. Welder was welding in 4F position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2114-FCM-1.

5CW

This Quality Assurance (QA) Inspector noticed grinding for removing the temporary attachments in progress for suspender bracket at CW side.

CB4

This Quality Assurance (QA) Inspector noticed welding for FL3 to CB at PP32, 33 and 34 for overhead stiffeners for west bound.

3AW to 3BW

This Quality Assurance (QA) Inspector noticed welding for 3AW to 3BW between PP 22 and 23 counter weight side X37A for road barrier.

3AE

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This Quality Assurance (QA) Inspector noticed for segment 3AE at PP 19 MAG inspection is in progress for temporary attachments areas which flush grinding been carried out.

1AE to 1BE

This Quality Assurance (QA) Inspector noticed MAG inspection for hold back area for segment splice between PP 10 and 11 for bottom panel I stiffener in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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